

Date: Wednesday, 01/04/2009 11:21:52 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : VERTICAL TUNNEL AFT CENTER
<b>Job Number</b> : 46778	
<b>Estimate Number</b> : 13587	
<b>P.O. Number</b> :	<b>Part Number</b> : D38223
<b>This Issue</b> : 01/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D38223 PRELIMINARY
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : IN0002
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : B PRELIMINARY
<b>Previous Run</b> : 44459	<b>Material</b> : MKYD6185S080P362015
<b>Written By</b> :	<b>Due Date</b> : 08/04/2009 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JULIO 09.04.01</u>	
<b>Comment</b> : Est. A New Issue 08/09/17 DL Rev B Dwg Update 09/02/09 DL	

Additional Product

PRELIMINARY ISSUE



Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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**Comment:** Qty.: 5.4170 sf(s)/Unit Total : 16.2510 sf(s)  
 6185 Kydex .080"

M109709

BB

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB

09/04/01

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB

09/04/01

(XY)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-3 and folio (FTA 9072 Prototype ) using tool DT 9072

Dwg. Rev. BFolio Rev. A

BB

09/04/01 x3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 01/04/2009 11:21:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL AFT CENTER

Job Number: 46778

Part Number: D38223

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/06 (X3)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Form 3

BB 09/10

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/06 (X3)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/06 (X3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Form 3

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

POSITIVE RECALL

EFFECTIVE 06.04.01 AUTH

DATE 09.04.14

09/04/15 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



U 09.04.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order: 46778
Description:	Part Number: D 3822-3
Inspection Dwg: D 3822 Rev: D	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: 09/04/02
------------------------	----------------

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.6	✓			
0.4	Min	0.412	✓			
0.1	Min	0.128	✓			
0.06		0.072	✓			
0.035		0.052	✓			
0.020	Min	0.060	✓			

Measured by: <u>BB</u>	Date: 09/04/02
Audited by: <u>[Signature]</u>	Date: 09/04/02
Prototype Approval: <u>[Signature]</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

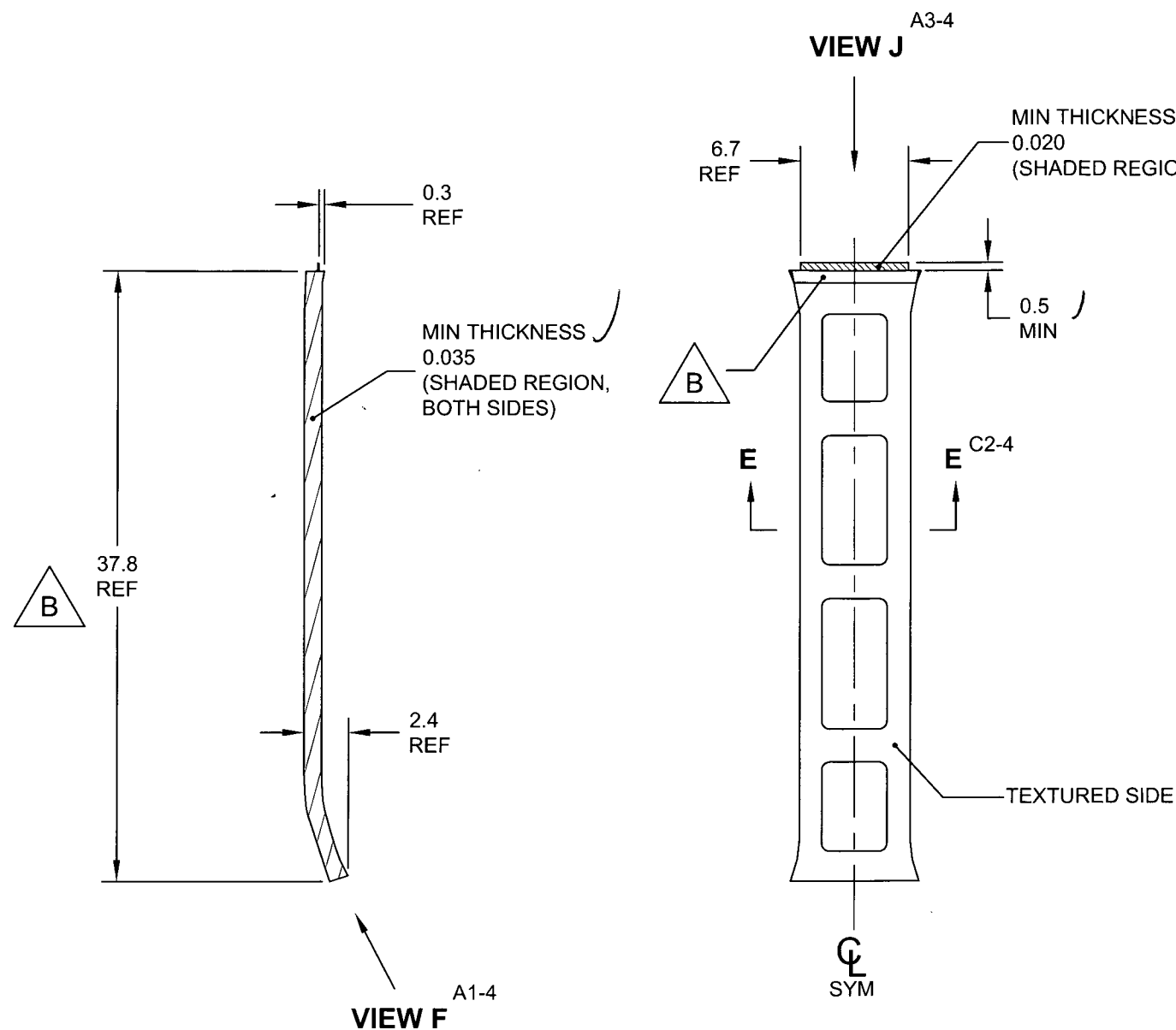
8 7 6 5 4 3 2 1

D

C

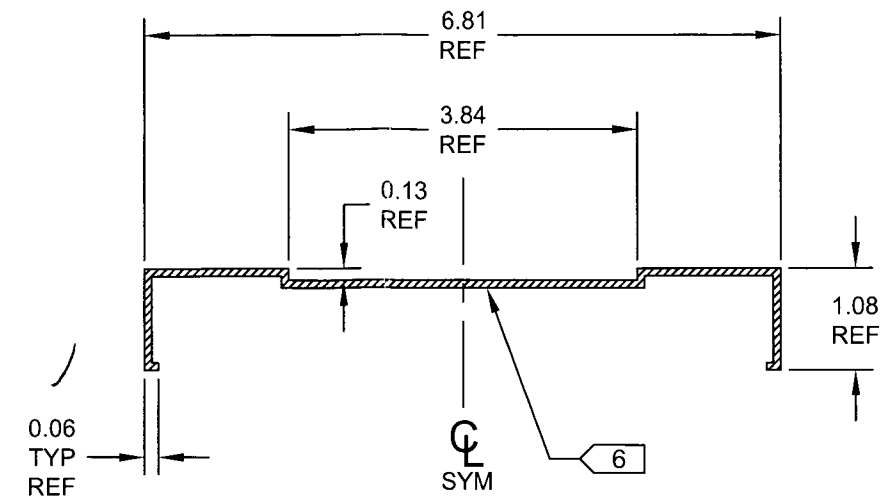
B

A



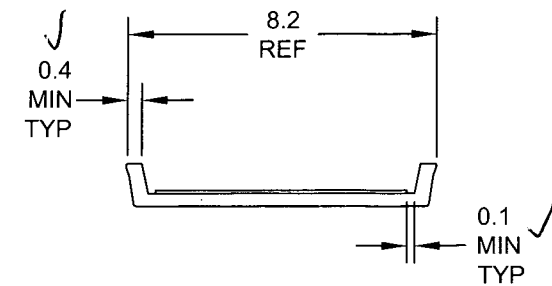
**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
  - 7) WEIGHT: 1.1 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD.
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

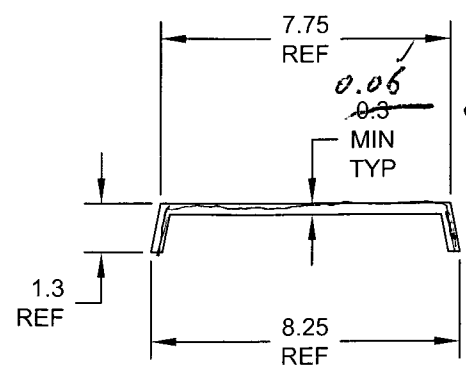


**SECTION E-E**  
SCALE 5X

*w/o 46778*  
**PRELIMINARY ISSUE**  
*PA 09.02.09*



**VIEW J**  
SCALE 2X



**VIEW F**  
SCALE 2X  
(ROTATED 90° CW)

DESIGN	<i>PA</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PA</i>		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3822	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.02.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D

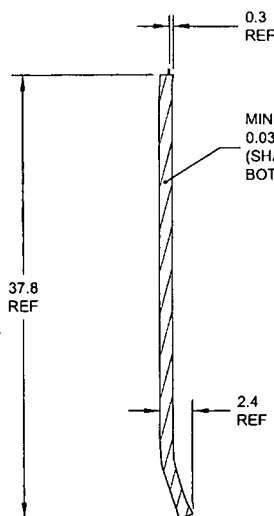
C

B

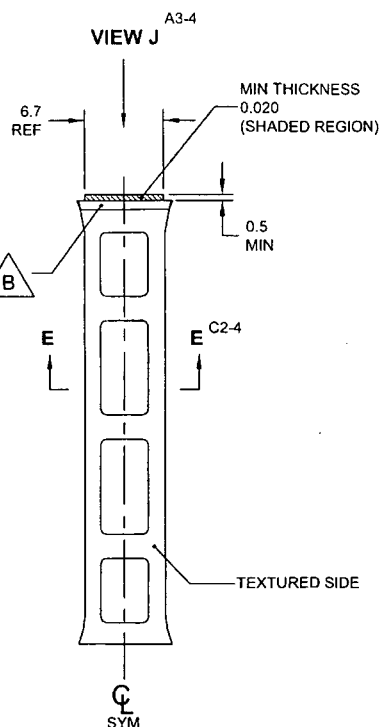
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C

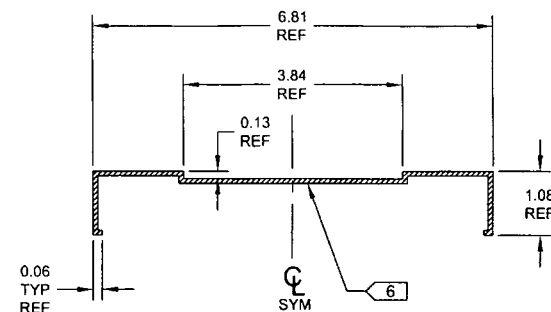
B



VIEW F  
A1-4



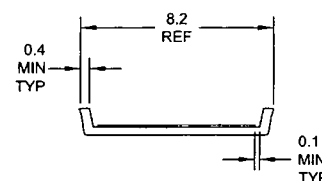
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(BELL 206 A/B)



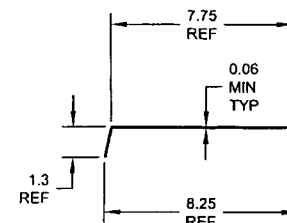
**SECTION E-E**  
SCALE 5X

46778

RELEASED  
2/10/11



**VIEW J**  
SCALE 2X  
D5-4



**VIEW F**  
SCALE 2X  
(ROTATED 90° CW)  
B7-4

**NOTES:**

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DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3822	SHEET 4 OF 6
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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